

Date: Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Split 1

| | |
|--|-------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : ARM |
| Job Number : 34477 | |
| Estimate Number : 12884 | |
| P.O. Number : <i>N/A</i> | Part Number : D3560044 |
| This Issue : 9/10/2007 | Drawing Number : D3560 UNDER REVIEW |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> | Drawing Revision : <i>PC</i> |
| Previous Run : 32648 | Material : <i>N/A</i> |
| Written By : _____ | Due Date : 9/17/2007 |
| Checked & Approved By : _____ | Qty: <i>12</i> Um: Each |
| Comment : Est Rev:A New Issue 07.05.24 EC | |

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .50" x 5.0"



Comment: Qty.: 1.3598 f(s)/Unit Total : 16.3170 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: *M105646*

7th 07/09/20

(12)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut blanks 15.500" long

7th 07/09/20

(12)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *A* & Dwg D3560 Rev: *C*
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

S.F. 07/07/22

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

S.F. 07/09/22

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 07/09/23

(12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07-10-11 | 1 | Scrap 2 arms because of crack will replace with new arm & plate | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:06 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D35921

PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

PLATE

334260 (4)

334478 (1)

07.10.10

5

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07.10.11

5

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07.10.11

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07.10.11

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.10.11

(5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07.10.11

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UJA

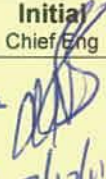




07.10.12

07.10.12

(5)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/15
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|---|---------------------------------|---|---|---|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07-10-11 | 7 | scraped two assemblies assemblies had to replace (cause of cracks) |  07/10/11 | welded two more assemblies |  07-10-11 |  07/10/11 |  07/10/11 |  07/10/11 |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:19:06 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34477

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

D 07.10.15

Job Completion



u 07.10.15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|-----------------------|--------|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 34477 |
| Description: Arm | | Part Number: | D3560-4 |
| Inspection Dwg: D3560 | Rev: B | Page 1 of 1 | |

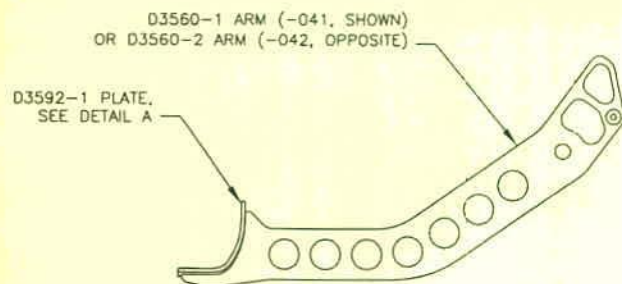
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

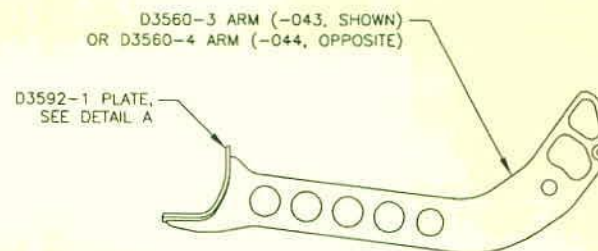
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| Ø0.507 | +0.000/-0.001 | .506 | / | | | |
| Ø0.196 | +0.005/-0.001 | .197 | | | | |
| Ø1.000 | +0.010/-0.001 | 1.003 | | | | |
| Ø0.900 | +0.010/-0.001 | .900 | | | | |
| 0.500 | +/-0.010 | .494 | | | | |
| 0.250 | +/-0.010 | .252 | | | | |
| 0.275 | +/-0.010 | .277 | | | | |
| 0.188 | +/-0.010 | .190 | | | | |
| 2.000 | +/-0.010 | 2.006 | | | | |
| 1.750 | +/-0.010 | 1.746 | | | | |
| 1.702 | +/-0.010 | 1.704 | | | | |
| Ø0.385 x 100° | +/-0.010 x 0.5° | .378 | | | | |
| 0.250 Deep | +/-0.010 | .245 | | | | |
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|-------------------|------------------|---------------------|-----|
| Measured by: J.F. | Audited by: J.F. | Prototype Approval: | N/A |
| Date: 07/09/22 | Date: 07/09/22 | Date: | N/A |

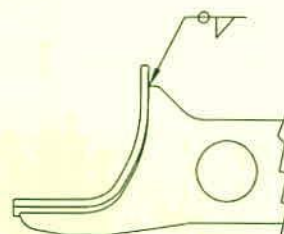
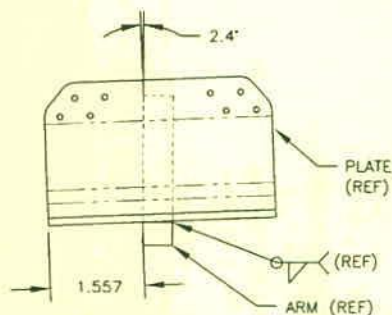
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|----------|
| A | 07.01.17 | New Issue | KJ/JLM | |
| B | 07.06.13 | Dimensions updated per Dwg Rev B | KJ/JLM | |



D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)



DETAIL A
(SCALE 1:1)

GENERAL NOTES

- 1) WELD PER QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

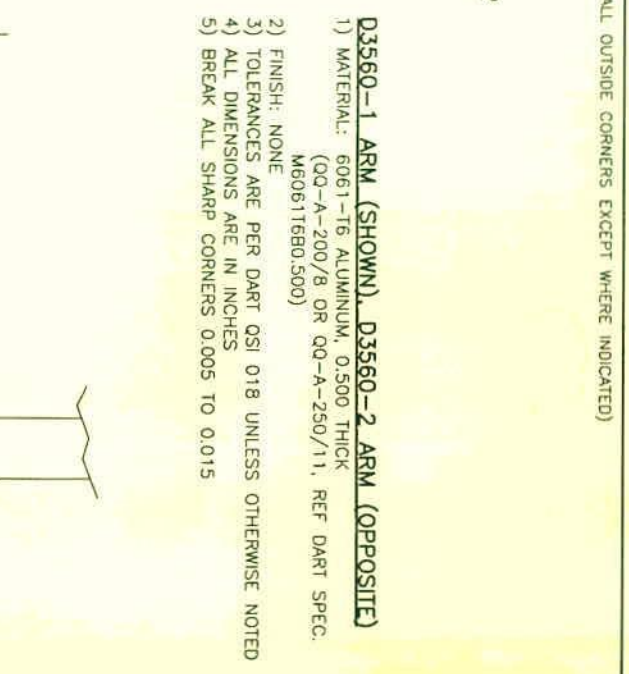
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07.06.19

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| | | |
|---------|----------|---|
| C | 07.06.19 | REMOVE POWDER COAT |
| B | 07.01.15 | REDESIGN AS WELDMENT, ADD PDKETS |
| A | 06.09.25 | NEW ISSUE |
| DESIGN | qf | DRAWN BY qf |
| CHECKED | h | APPROVED h |
| DATE | 07.06.19 | TITLE |
| | | ARM WELDMENT |
| | | SCALE 1:4 |
| | | DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA |
| | | DRAWING NO. D3560 |
| | | REV. G SHEET 1 OF 3 |



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| DESIGN | 99 | DESIGN BY | 99 |  DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | |
| DATE | 07.06.19 | DRAWING NO. | D3560 | REV. C |
| | | TITLE | ARM WELDMENT | SHEET 2 OF 3 |
| | | | | SCALE |

RELEASED
07-06-24

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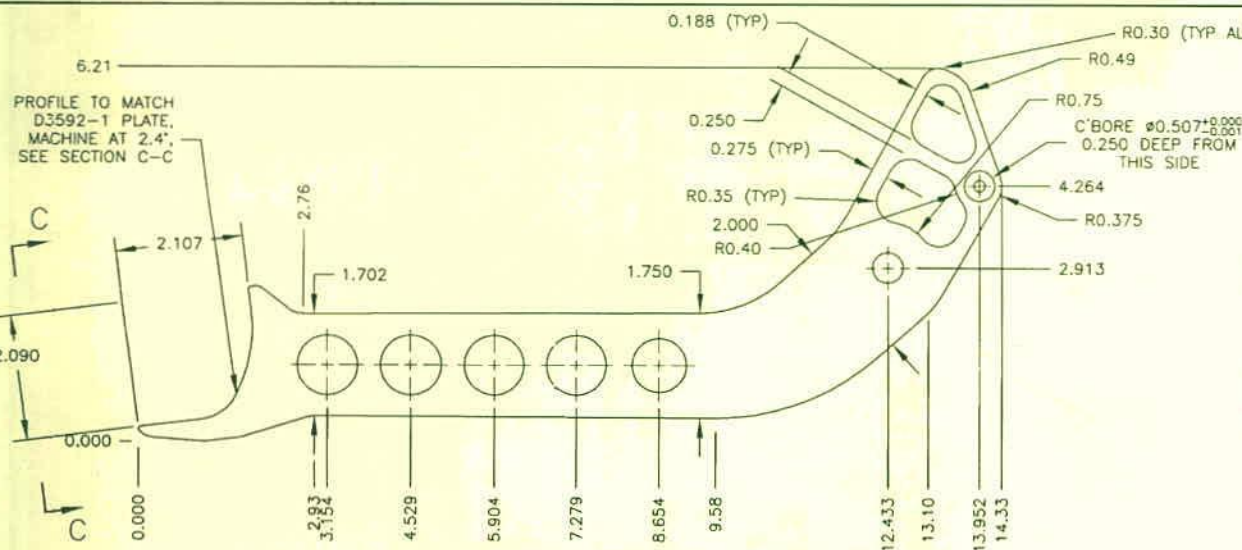
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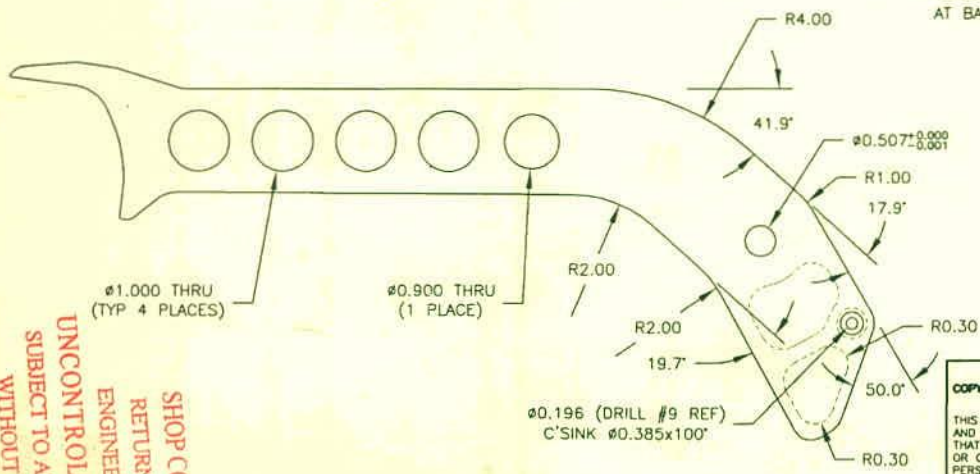
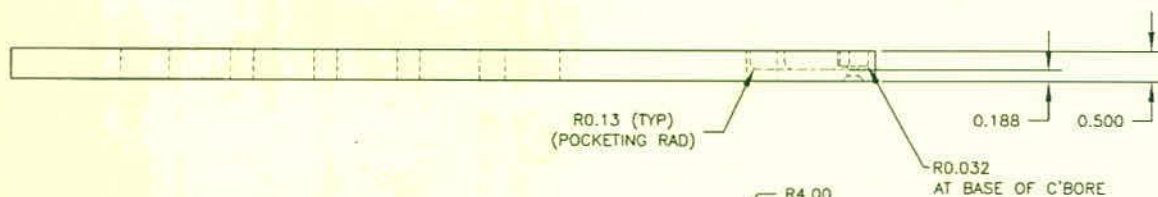
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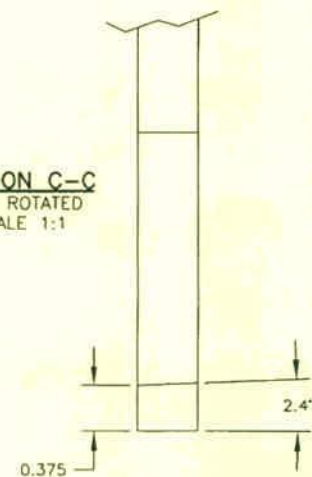


D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

- 1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK
(QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.015



SECTION C-C VIEW ROTATED SCALE 1:1



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|---------|----------|----------|--------------|----------------------|--|
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| CHECKED | | APPROVED | | DRAWING NO. D3560 | REV. C SHEET 3 OF 3 |
| DATE | 07.06.19 | TITLE | ARM WELDMENT | SCALE | 1:2 |

NO. 34477

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